

Date: Friday, 17/08/2007 11:21:21 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR ADAPTER
Job Number : 34084 - Estimate Number : 12133
P.O. Number : *NA* Part Number : D3476043
This Issue : 17/08/2007 S.O. No. : *NA* Drawing Number : D3476 REV A
Prsht Rev. : NC Project Number : N/A
First Issue : *MA* Type : SMALL / MED FAB Drawing Revision : A
Previous Run : 32042 Material : *MA* Due Date : 11/09/2007 Qty: *3* Um: Each
Written By : *[Signature]*
Checked & Approved By : *[Signature]*
Comment : Est Rev:A New Issue 06-01-31 JLM
est rev B added comment @ # 5.0 06.11.01 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34763 DOME



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part Number Description Batch
1 D3476-3 blower motor adapter *B27025* x *(3)mx* *mf*

2.0 D34767 TUBE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Qty Part Number Description Batch
2 D3476-7 Tube *B34105* x *(2)mx*, *B34493* x *(4)mx* *mf*

3.0 D34761 duct



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Qty Part Number Description Batch
1 D3476-1 Duct *B34105* x *(3)mx*, *B36162* x *(3)mx* *mf*

4.0 NAS1031C3W Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Qty Part Number Description Batch
4 NAS-1031C3W Nutplate *M105728* x *(12)mx*, *M106101* x *(4)mx* *mf*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/16	6	Split w/o was split gts 1 balance 3	SB	07/10/16	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 01/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:21:21 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 34084

Part Number: D3476043

Job Number:



Seq. #:

Machine Or Operation:

Description :

***** D3476-1 goes on top of D3476-3 *****

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



07/12/12

③

Comment: VISUAL INSPECTION OF SPOT WELDING

SA 07/10/16

①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/12/12

③

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: SA

mf 07-12-14

③

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DA 12/18

③

Job Completion



mi 2007/12/17

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

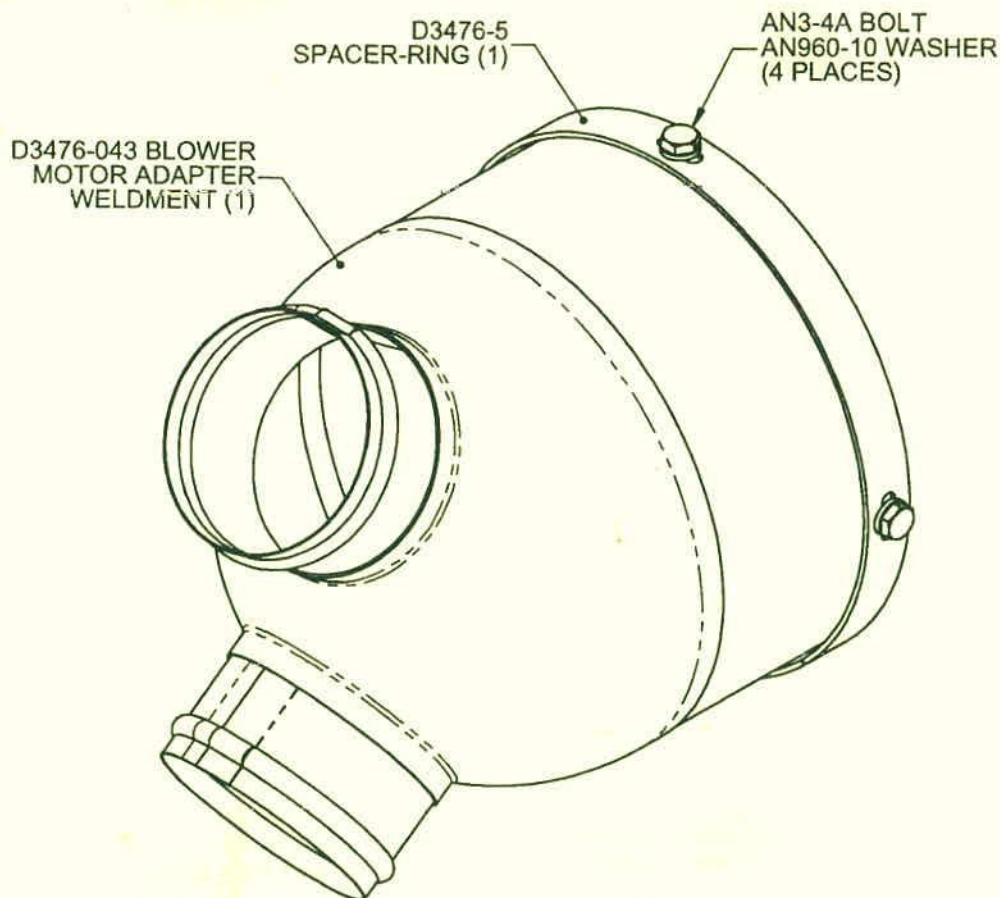
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	
A	06.01.27	NEW ISSUE	

[Signature] 06.04.03



D3476-041 BLOWER MOTOR ADAPTER

- 1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

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NO. *34084*

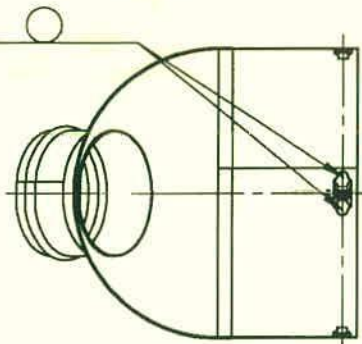
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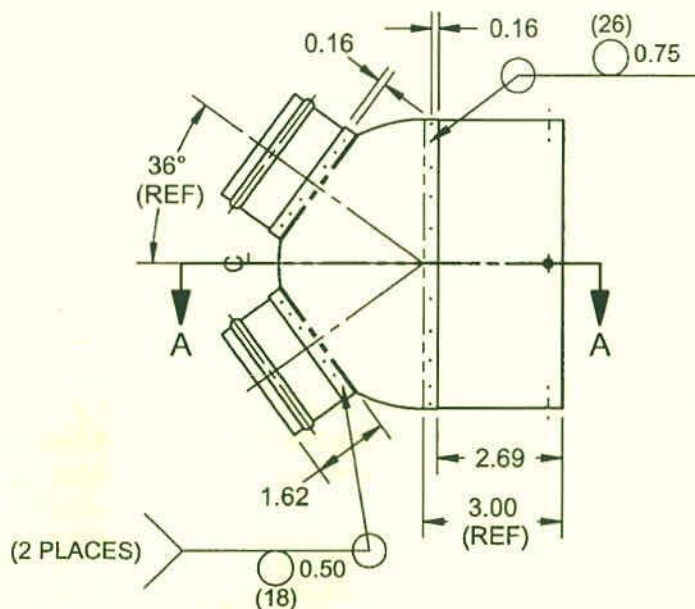


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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

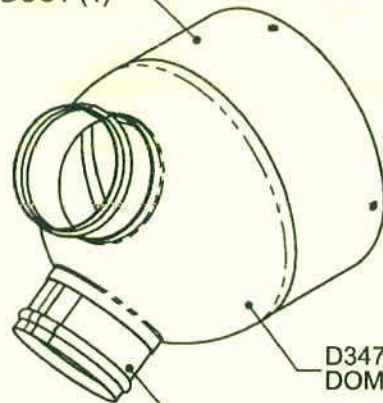
LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)



SECTION A-A

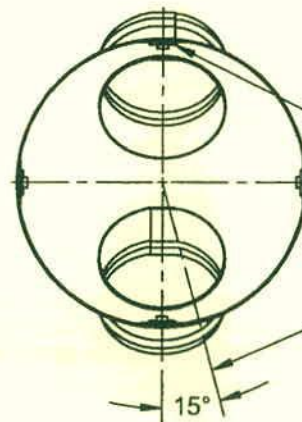


D3476-1
DUCT (1)



D3476-3
DOME (1)

D3476-7 TUBE
(2 PLACES)



NAS-1031C3W
NUT PLATES
(4 PLACES)

OFFSET SEAM
ON DUCT

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06.04.23
34084

D3476-043 BLOWER MOTOR ADAPTER WELDMENT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

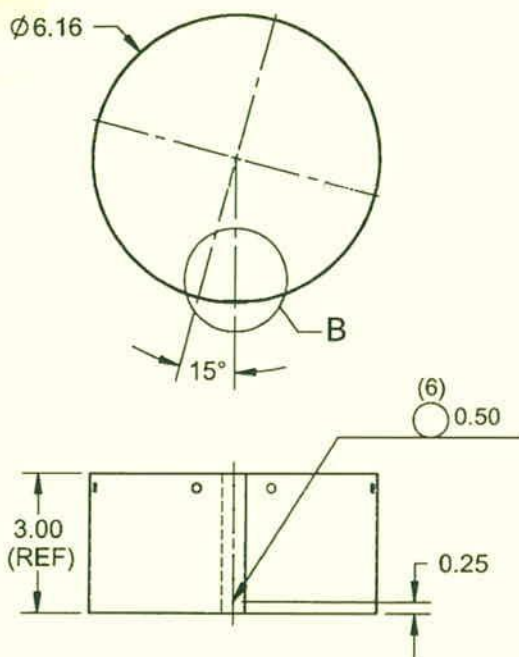
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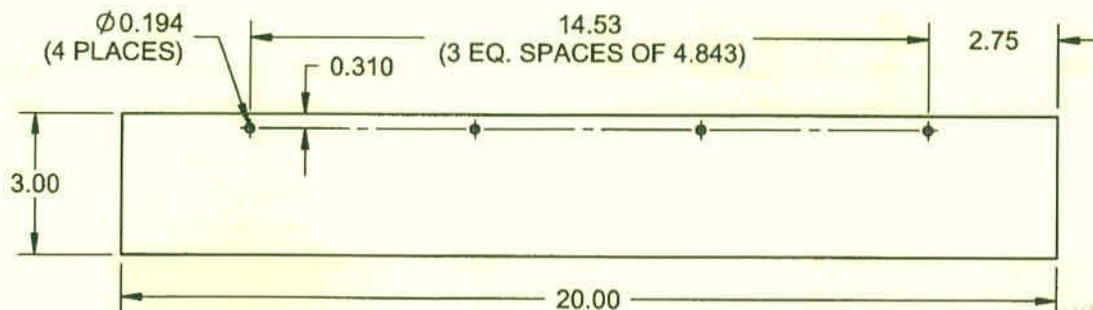
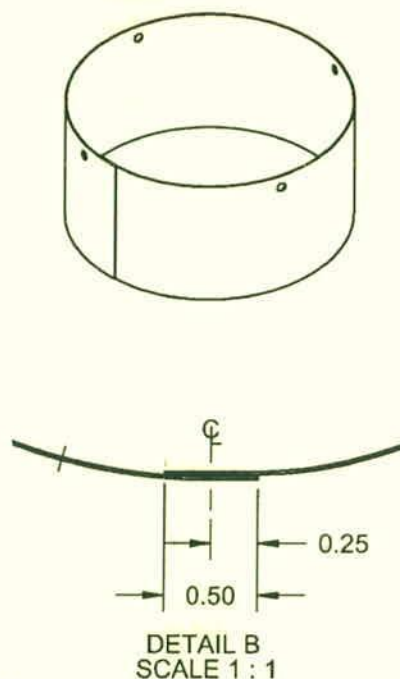


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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

[Signature] 06.01.03



D3476-1 DUCT



D3476-1F DUCT FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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1. The first part of the report is a general introduction to the subject of the study. It discusses the importance of the study and the objectives of the research. It also provides a brief overview of the methodology used in the study.

2. The second part of the report is a detailed description of the study area. It includes information about the location of the study area, the population of the study area, and the characteristics of the study area. It also discusses the data sources used in the study.

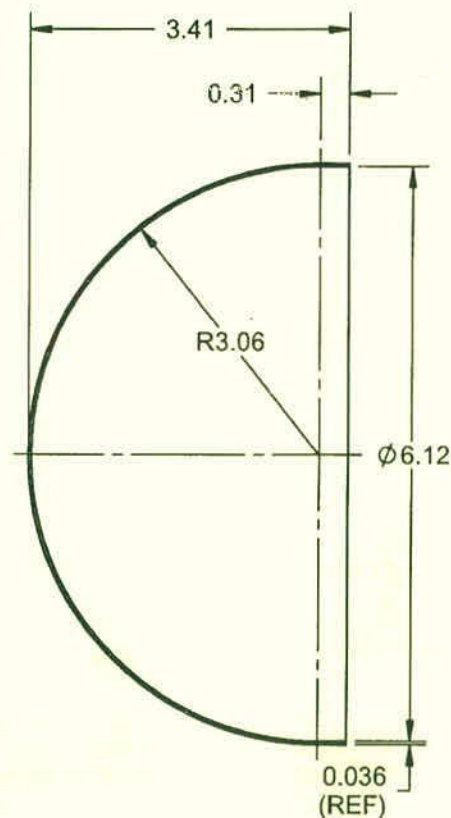
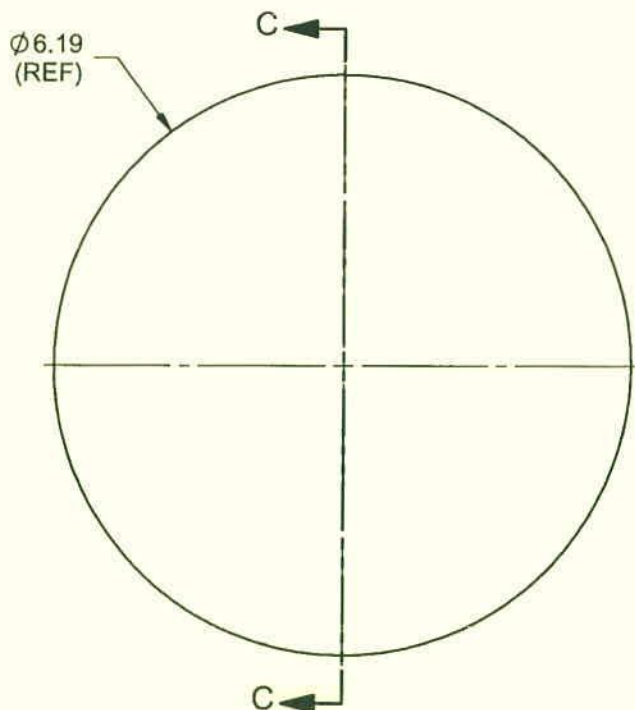
3. The third part of the report is a detailed description of the study results. It includes information about the findings of the study, the conclusions drawn from the findings, and the implications of the findings. It also discusses the limitations of the study and the need for further research.

4. The fourth part of the report is a conclusion and recommendations section. It summarizes the findings of the study and provides recommendations for future research. It also discusses the implications of the findings for policy and practice.



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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED
06.04.03 *H*



SECTION C-C

D3476-3S DOME, SPINNING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED)
2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING
OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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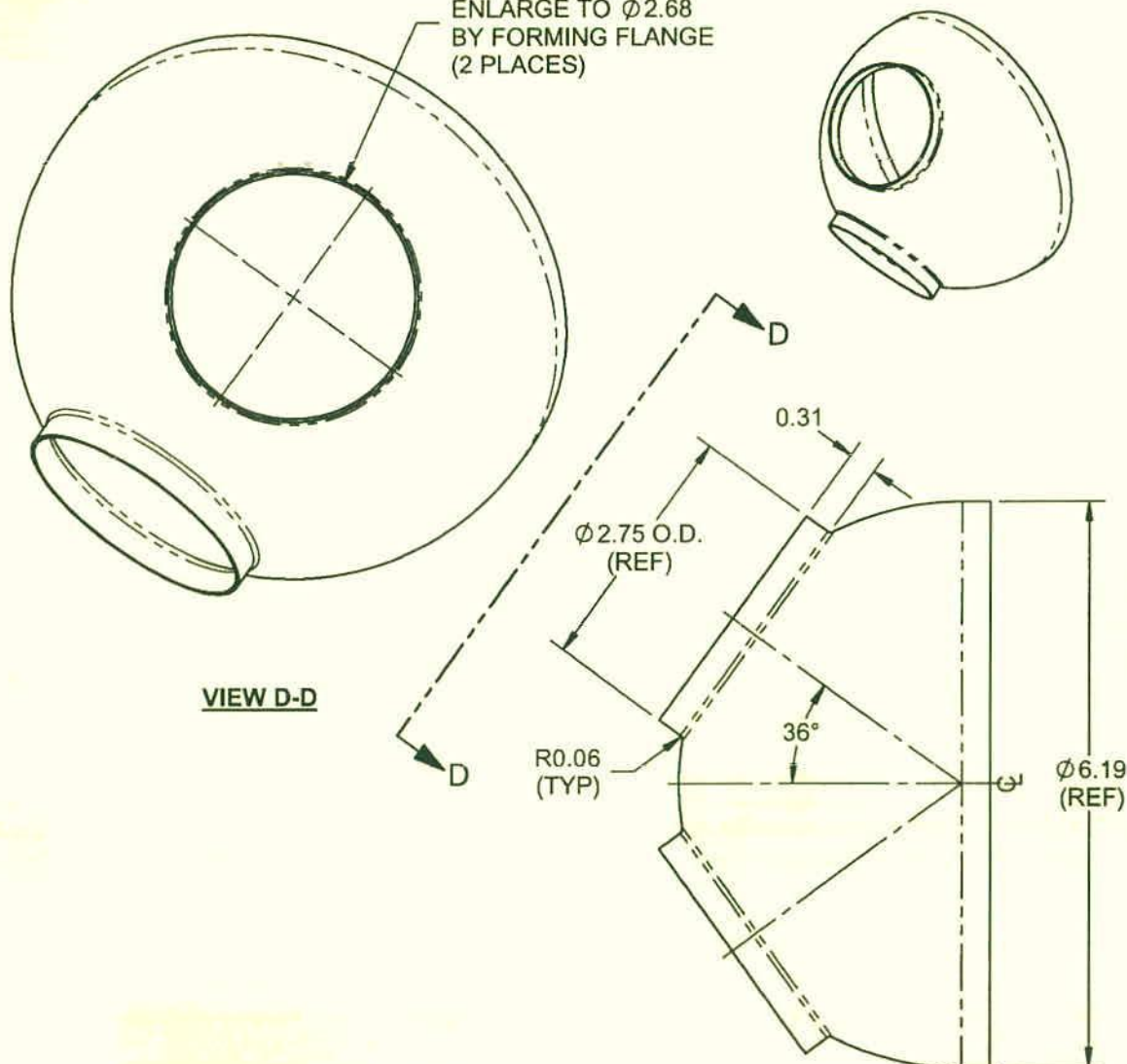
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

06.04.03

CUT $\phi 2.25$ HOLE,
ENLARGE TO $\phi 2.68$
BY FORMING FLANGE
(2 PLACES)



VIEW D-D

D3476-3 DOME

NOTES:

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

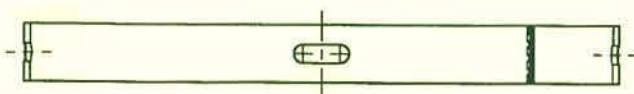
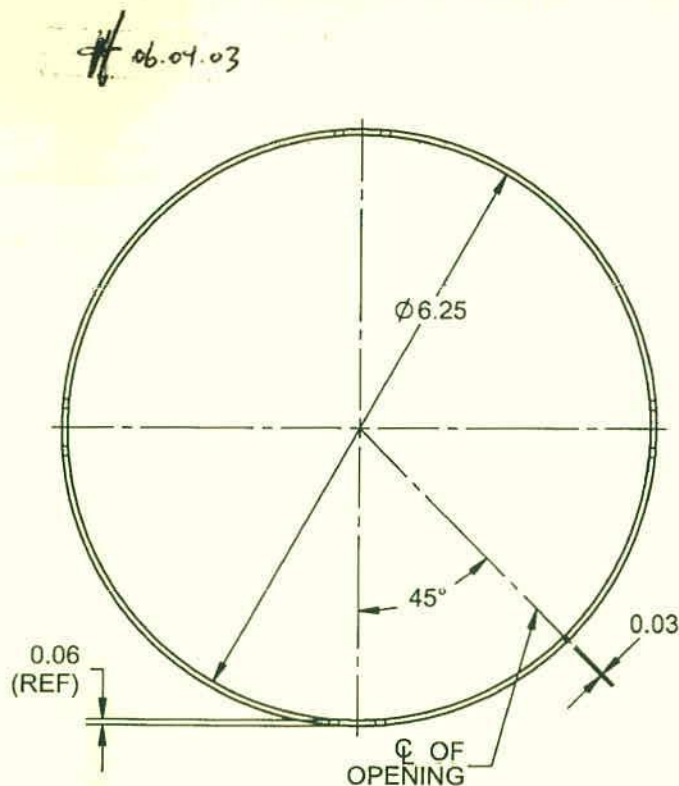
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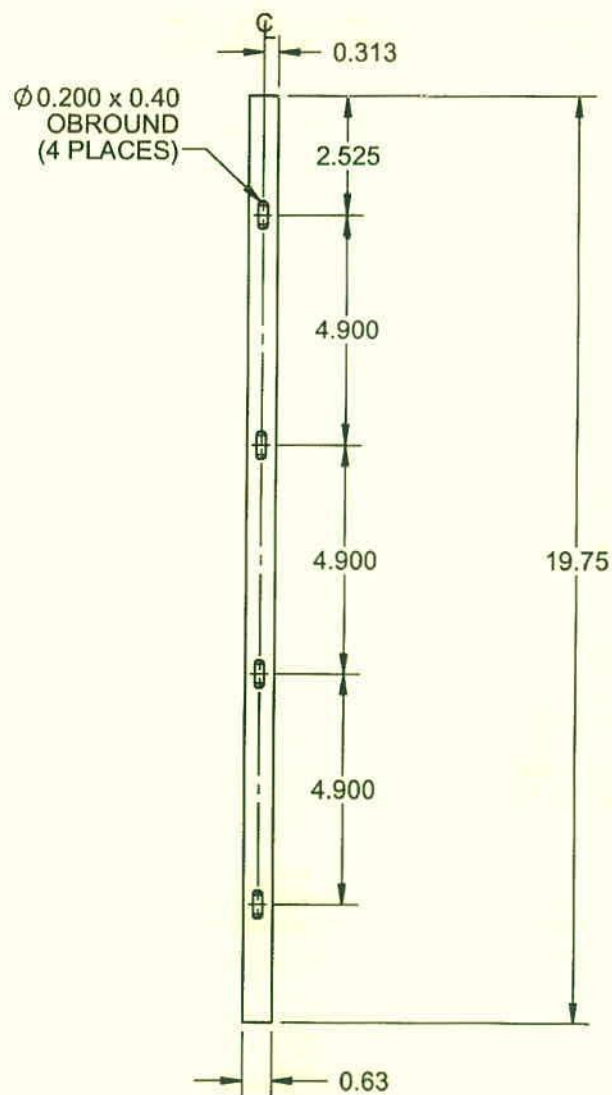
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DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:2



D3476-5 SPACER-RING



**D3476-5F SPACER-RING
FLAT PATTERN**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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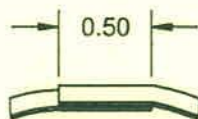
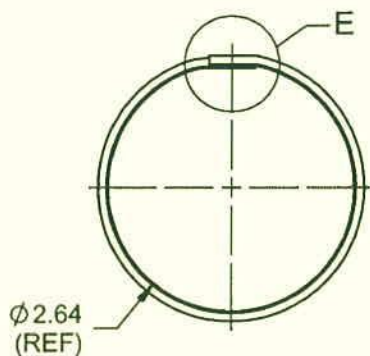
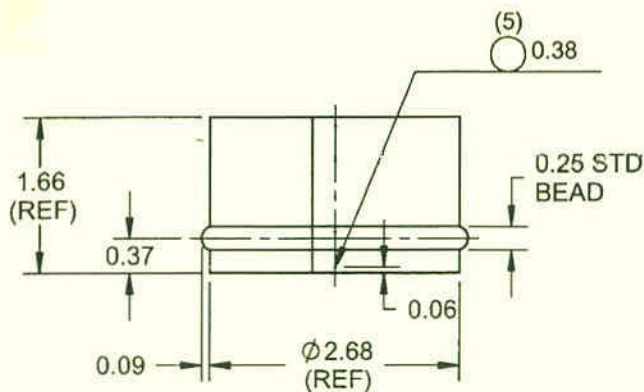
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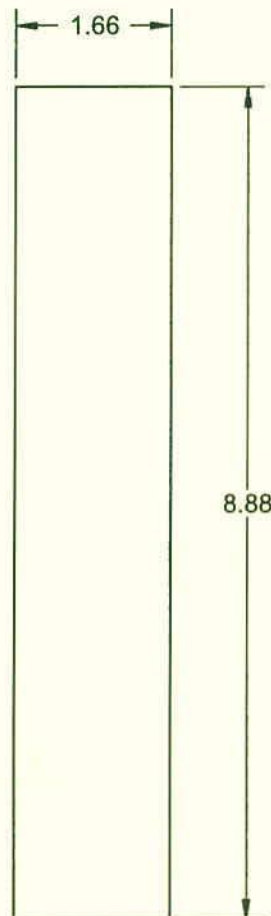
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

[Handwritten] 06.04.03



DETAIL E
SCALE 1:1

D3476-7 TUBE



D3476-7 TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 111

EMPLOYEE: Melanie Fatteruf

PART NUMBER: D3476-013

JOB NUMBER: B 34014

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.075

GROUP SPECIFICATION

- ☐
☐
☒

Group 1: Aluminum & magnesium

Group 2: Iron; nickel; cobalt

Group 3: Titanium TS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/01/12
QUALIFIER: 875

